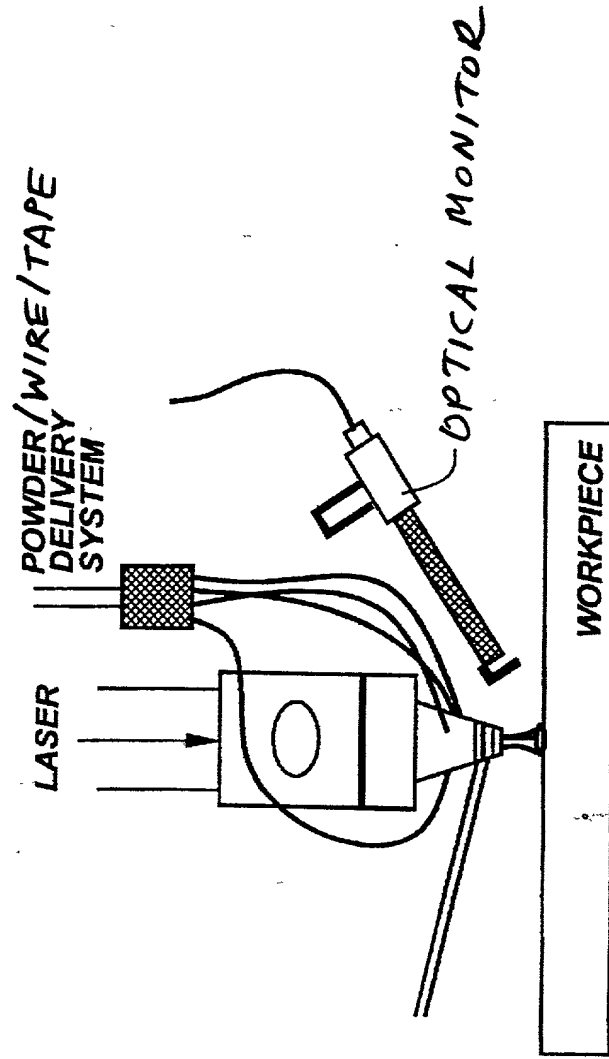






**Figure - 2**





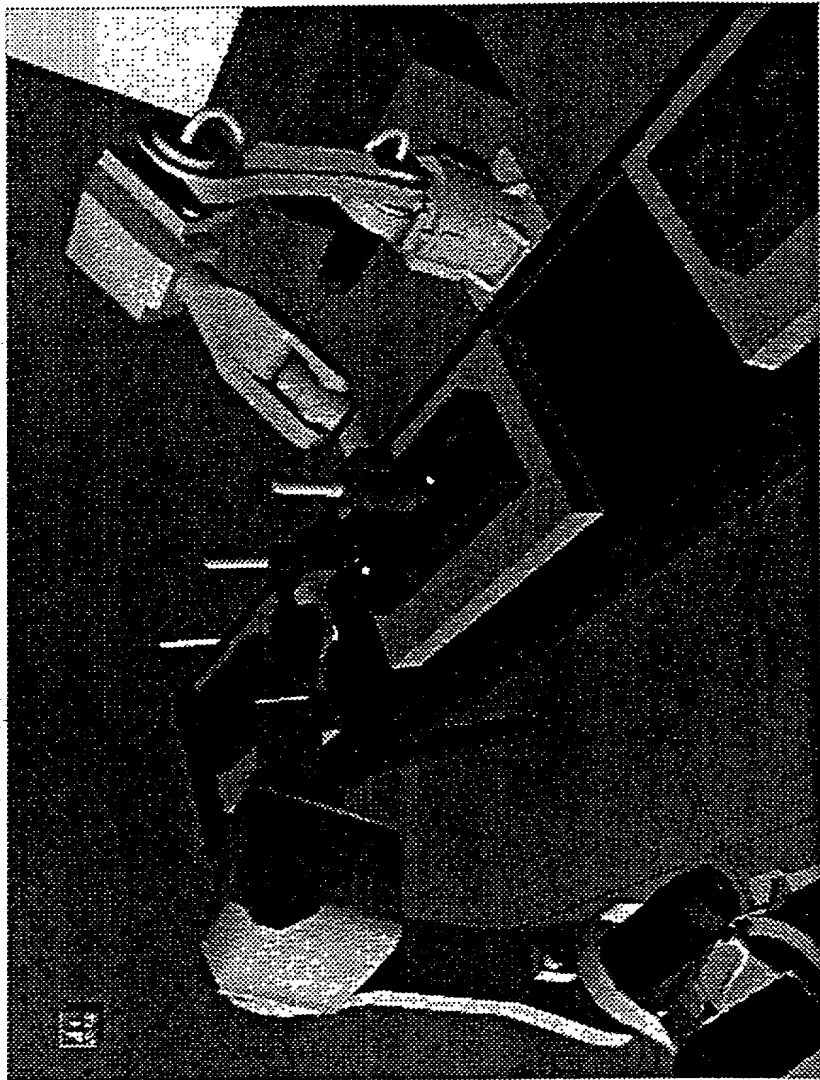


Figure 3. Robotic embodiment of DMD



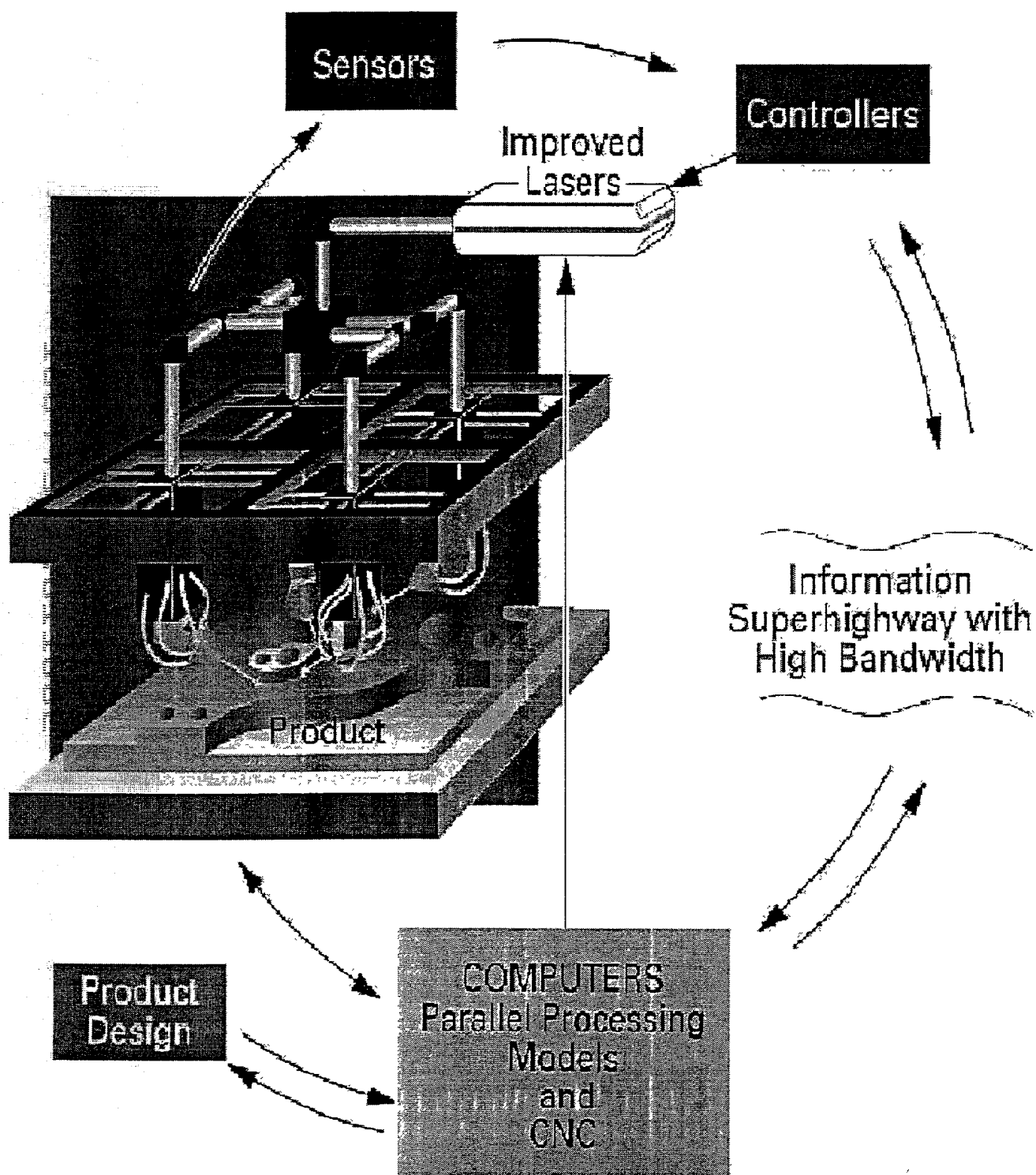


FIGURE 4



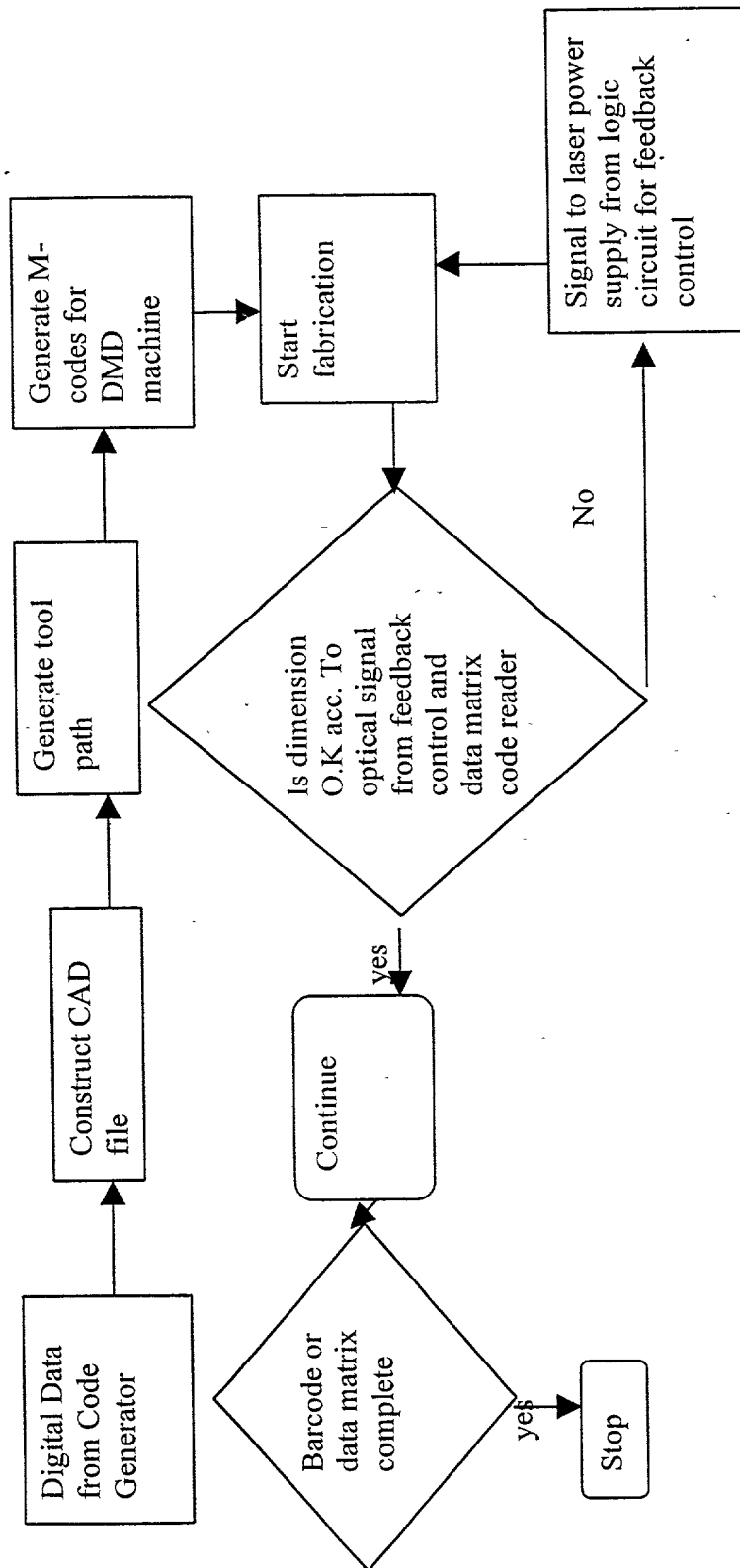


FIGURE 5



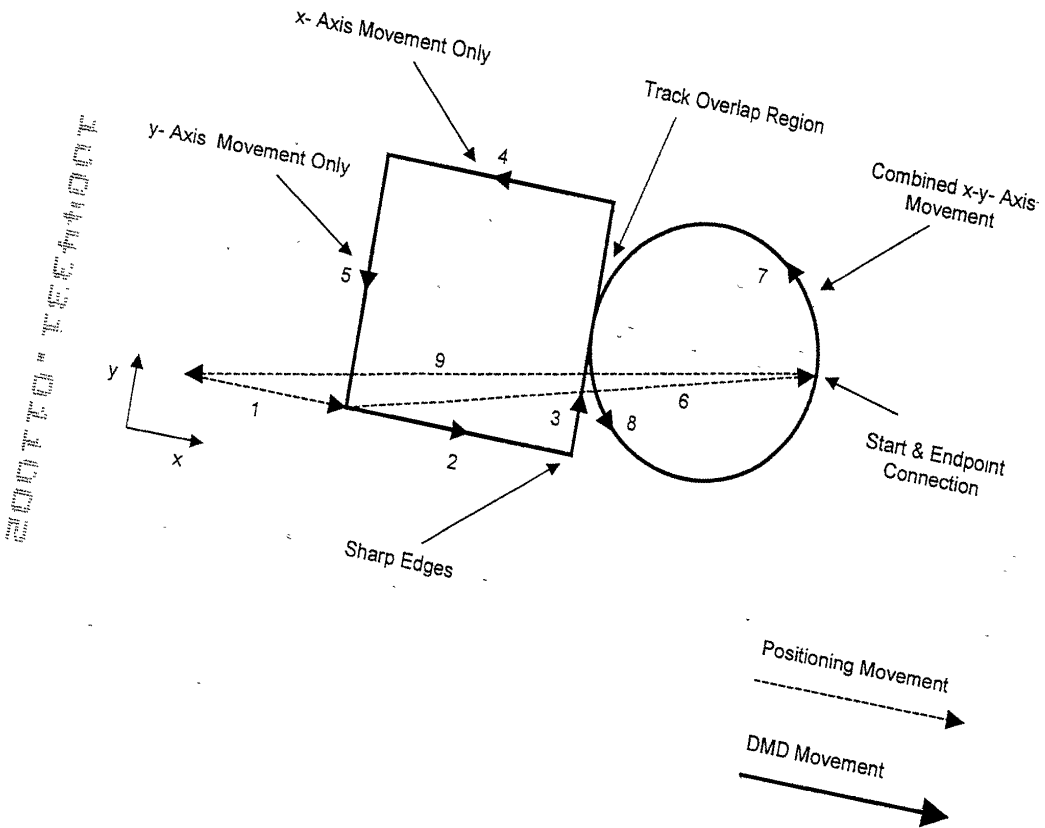


FIGURE 6



CONFIDENTIAL

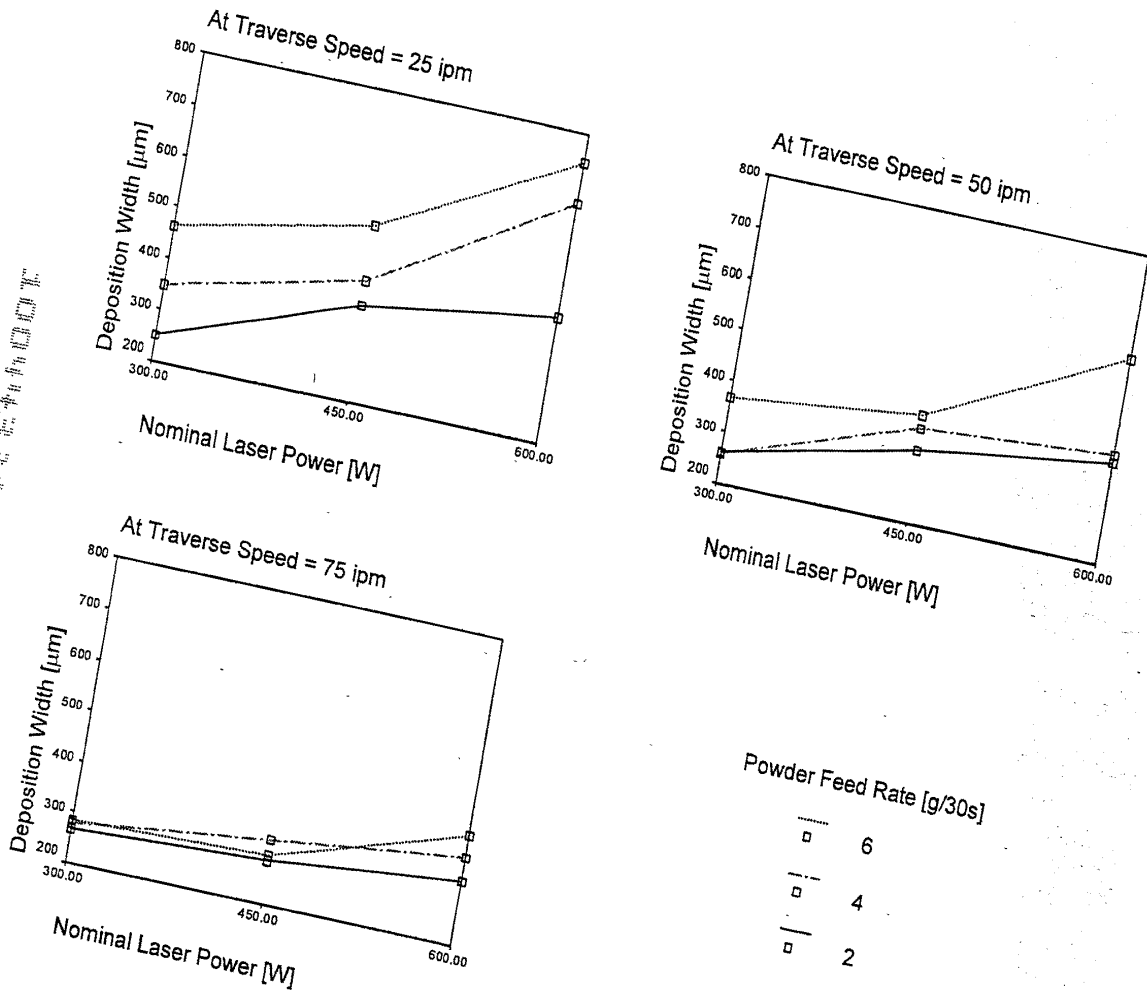
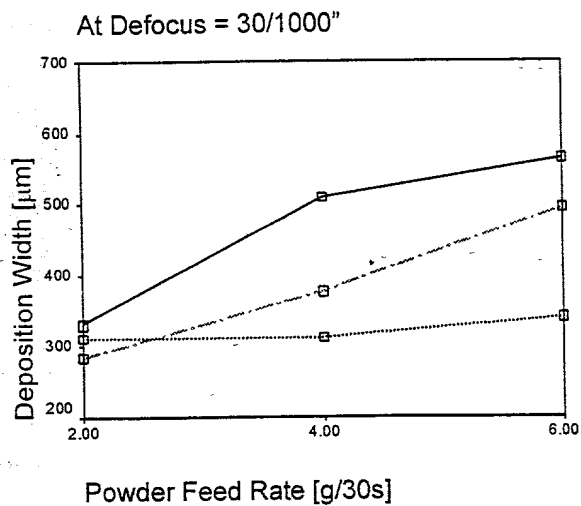
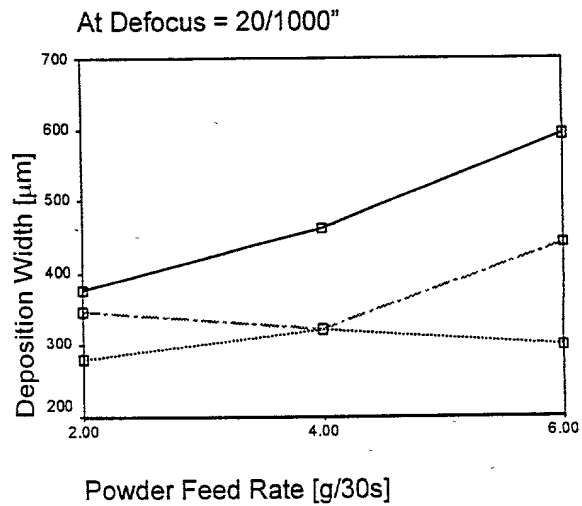
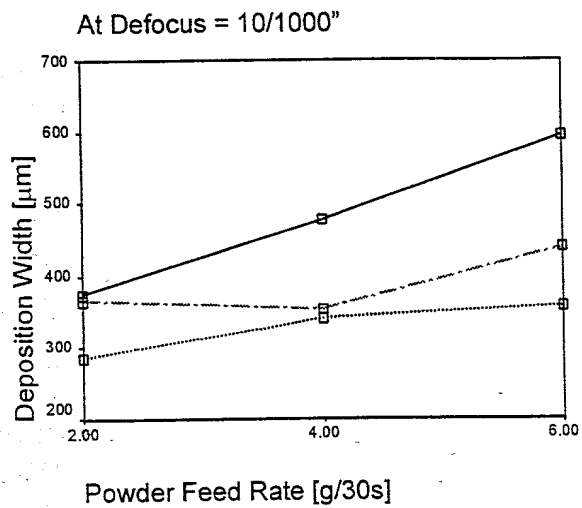
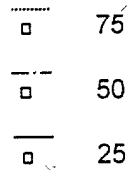


FIGURE 7





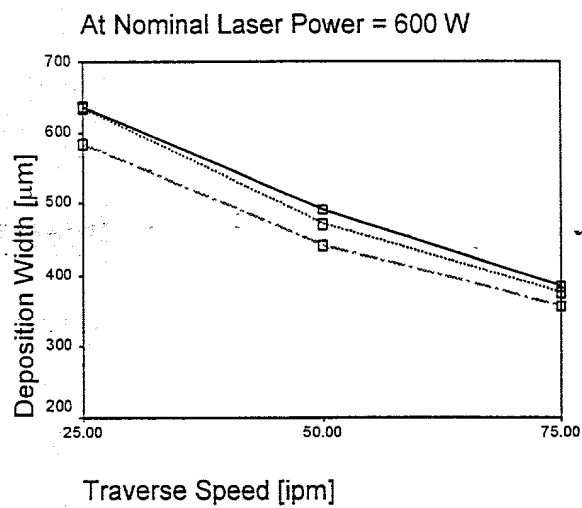
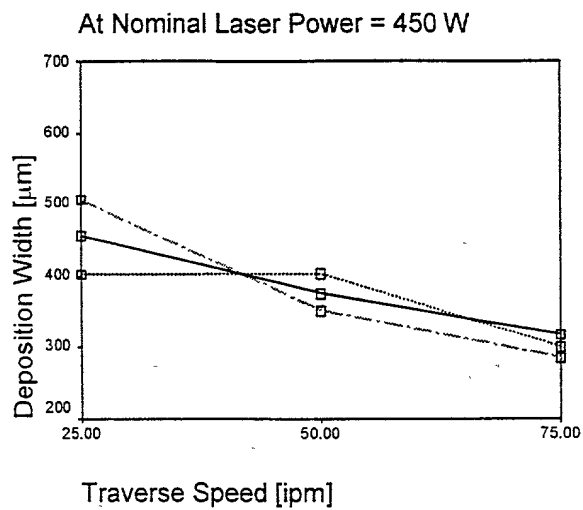
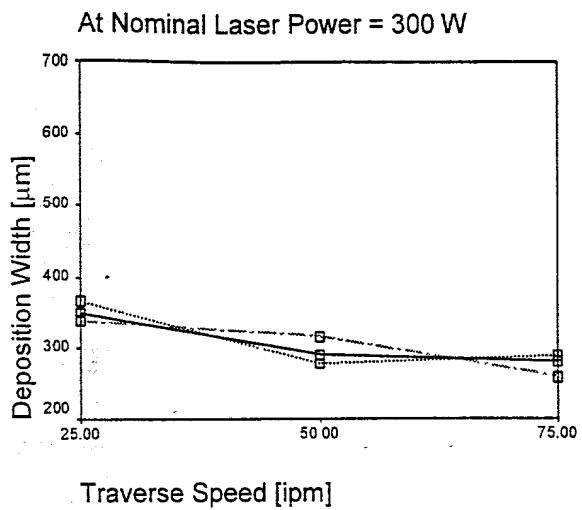
Traverse Speed [ipm]



**FIGURE 8**



2007-10-10 14:44:00

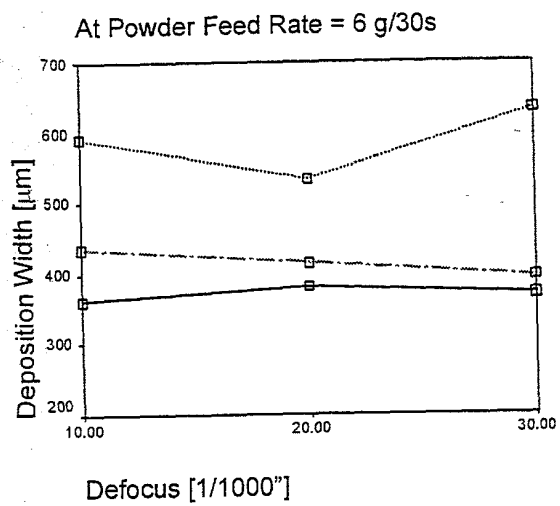
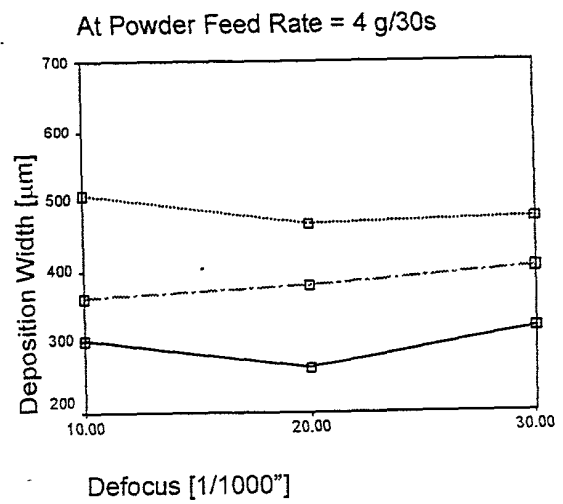
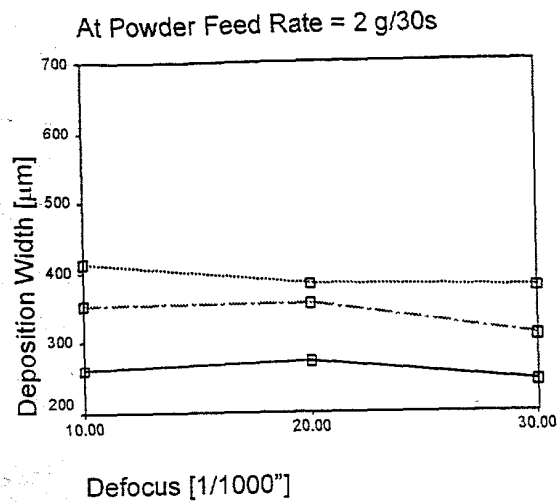


Defocus [ $1/1000''$ ]

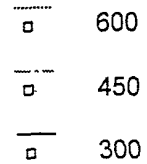
- 30
- 20
- 10

**FIGURE 9**





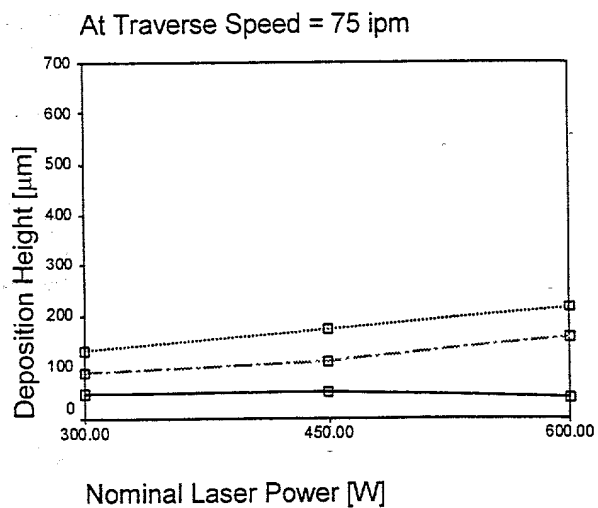
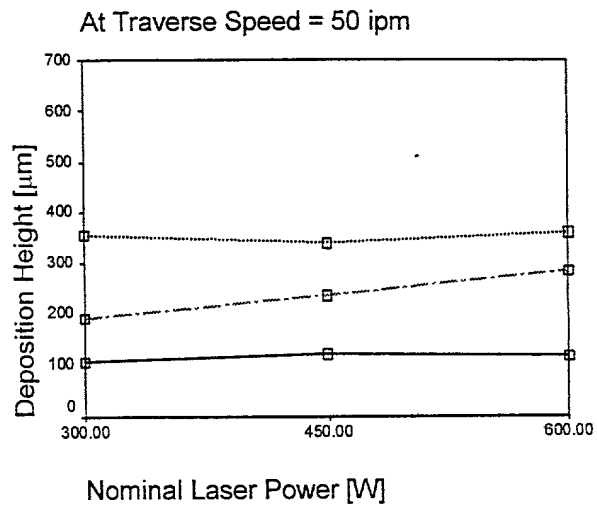
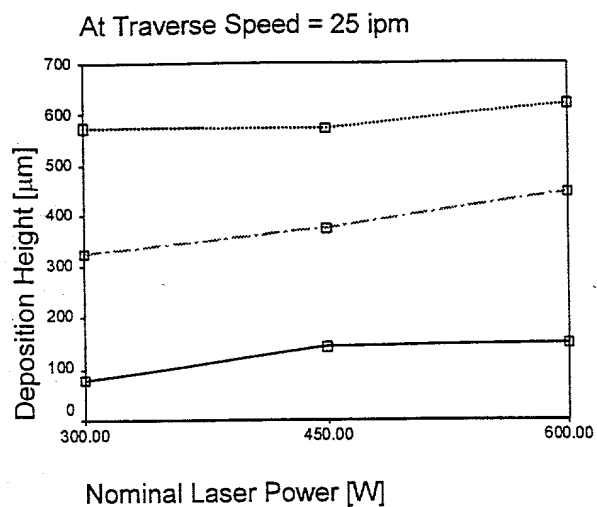
Nominal Laser Power [W]



**FIGURE 10**



2007-10-27 14:00



Powder Feed Rate

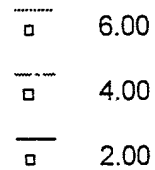


FIGURE 11



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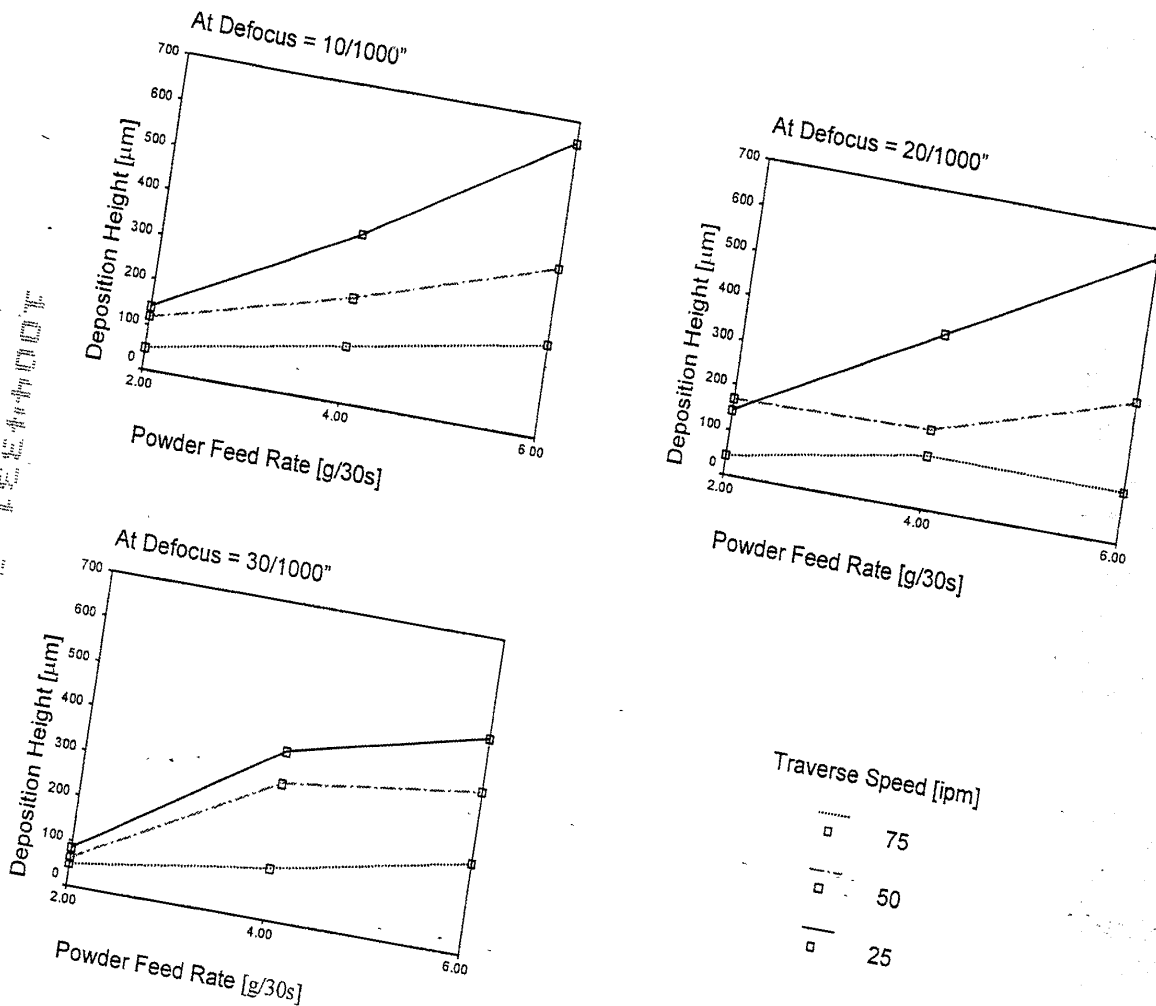
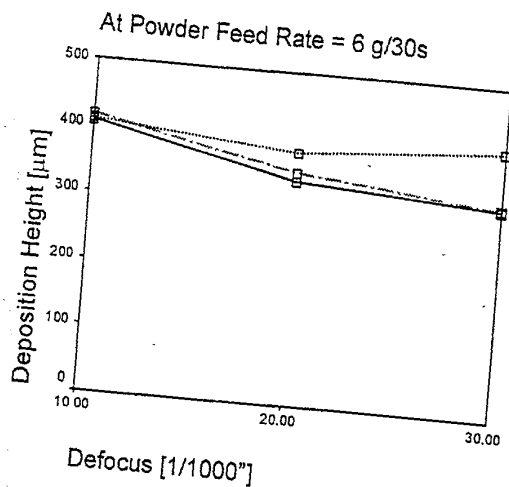
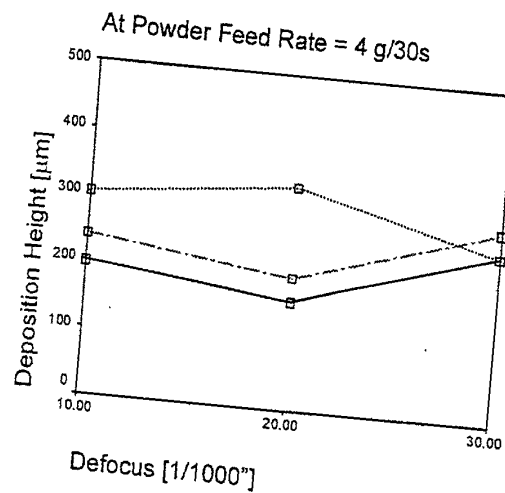
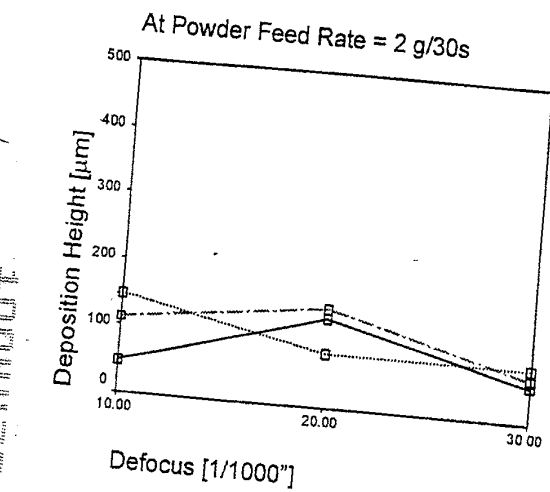


FIGURE 12



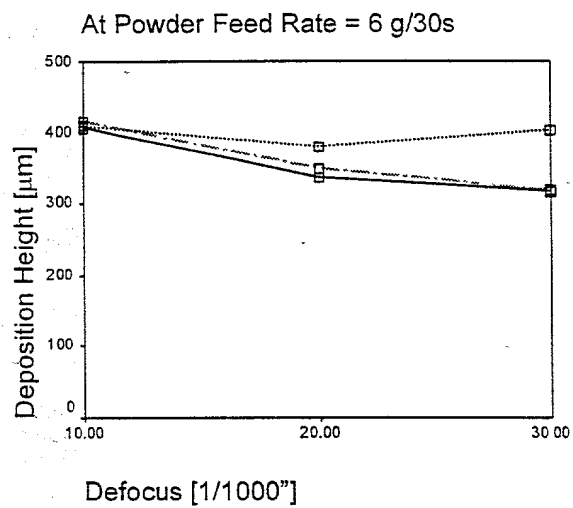
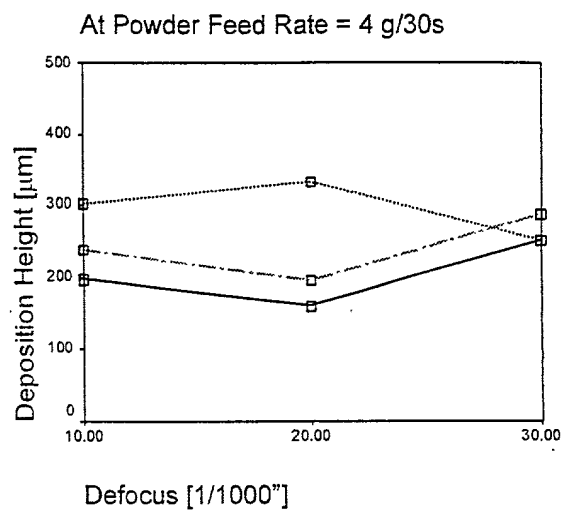
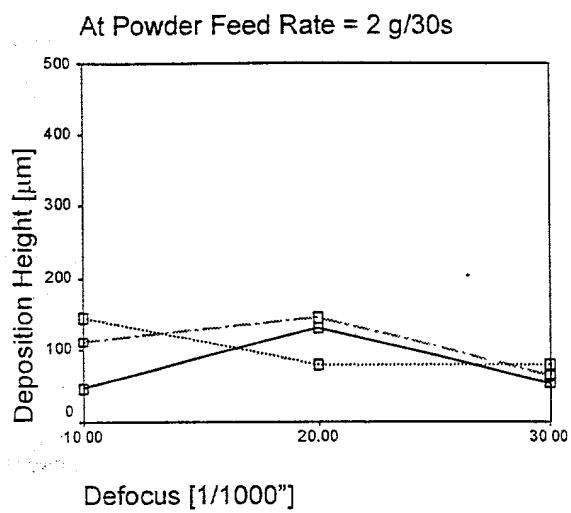


Nominal Laser Power [W]

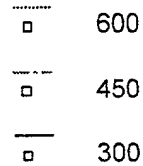
- 600
- 450
- 300

FIGURE 13





Nominal Laser Power [W]



**FIGURE 14**